

Date: Friday, 9/29/2006 10:43:23 AM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	STEP SPACER
Job Number :	28791C		
Estimate Number :	10354		
P.O. Number :	N/A	Part Number :	D2322
This Issue :	9/29/2006	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D2322 REV C
First Issue :	N/A	Project Number :	N/A
Previous Run :	27756C	Drawing Revision :	C
		Material :	N/A
Written By :	<u>[Signature]</u>	Due Date :	10/10/2006
Checked & Approved By :	<u>[Signature]</u>	Qty:	20
Comment :	Est Rev:A New Issue 05-11-07 JLM Est Rev:B Now on Waterjet 06-07-03 JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M2024T3S040	2024-T3 .040 sheet
-----	-------------	--------------------



Comment: Qty.: 0.2132 sf(s)/Unit Total: 4.2630 sf(s)
 Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick
 (M2024T3S.040)
 Identify as D2322
 Batch: M102448

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D2322
 Dwg Rev: C
 Prog Rev: C

2-Deburr if necessary

SAD 06:10:29 (20)

SAD 06:10:30 20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06:10:29 (20)

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

[Signature]
 06:10:30

[Signature]
 06/10/20 (20)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE
 Form as per Dwg D2322

SAD 06/11/06 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 06/11/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/29/2006 10:43:23 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 28791C

Part Number: D2322

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AS 06/11/06 (20)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

PC 06/11/10 x 20

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 6/4/13 (20)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 37 PC 6/4/13 (20)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 06/11/13 (20)

Job Completion



C 2061113

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART



DESIGN BW	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED [Signature]	DRAWING NO. D2322	REV. C SHEET 1 OF 1
DATE 98.09.29	TITLE STEP SPACER		SCALE 1:2
A	94.10.14	NEW ISSUE	
C	98.09.29	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER NCR 001	

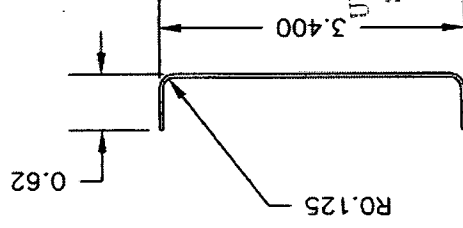
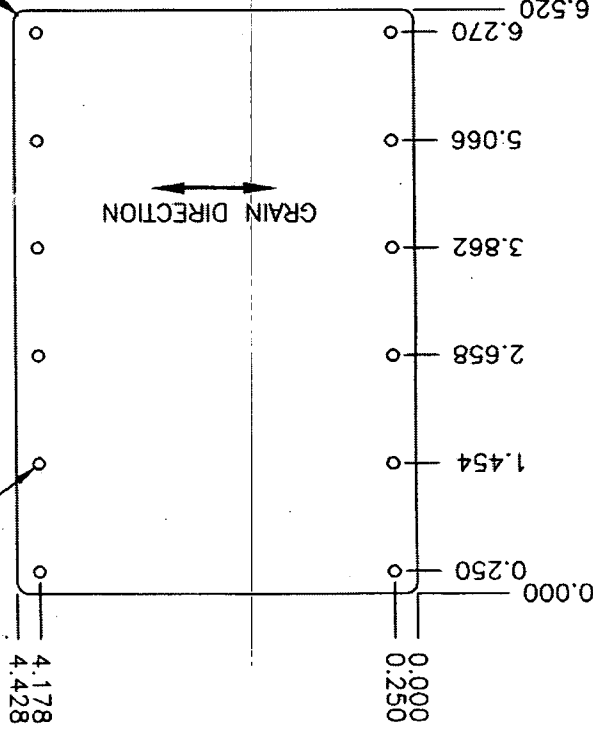
RELEASED
18.10.08 DS

UNDER REVIEW

01.07.15 GP
DESIGN OK, BUT CHECK WITH
DTS BEFORE MANUFACTURE
OK GP 04.11.19

Ø0.128 (TYP 12 PLACES)

R0.125
(TYP 4 PLACES)



MATERIAL: 2024-T3 (00-A-250/5) 0.040 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28791C